

Ship Today

Work Order ID 84720

84720

Page 1

May-22-12 1:04:25 PM

Item ID: D2199-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Details
 Start Date: 22/05/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2199	Rev E1								
100		0.00							
100	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch per Dwg. D2199 and Spec Control Dwg D2638								
110		0.00							
110	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
120		0.00							
120	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

St 12/07/17

4

7

4

0

At

12.07.18
FF 12-08-01

DAS
15
2-09

121128

2

2

410 ->

W/O: 84720		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ199-1 PAR #: _____ Fault Category: Sub NCR: Yes No DQA: Yes Date: 12/12/21
 Resolution: _____ Disposition: Scrap QA: N/C Closed: Yes Date: 12/12/24

NCR: 12-2148		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/21	10	Found at inspection that D1 & 2 struts were punched no longer R.L. operation	W 12/08/21	Scrap + Destroy struts Parts * cut off puncher ends AND Restock material under original B#, 122312 No replace	EB 12/11/28	DAS 15 12/11/28	W 12/08/21	DAS 16 12/08/21

51.09
x 2
102.18

NOTE: Date & initial all entries

Work Order ID 84720

84720

Page 2

May-22-12 1:04:25 PM

Item ID: D2199-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Details

Stop *NS2*

Start Date: 22/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

Quality Control

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

Packaging

0.00

2X ϕ 12/11/28 m-k

2 ϕ 12/11-28 238

2x SP 12/11-28

2027 5220

m 123383

10:45
40001=

11:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-22-12 1:04:25 PM

Item ID: D2199-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Details

Stop *NS2*

Start Date: 22/05/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 05/06/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12-11-28

mk
12-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

May-22-12 1:04:29 PM

Work Order ID: 84720

84720

Parent Item: D2199-1

D2199-1

Parent Item Name: Strut Details

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B02.06.10Added finish NG/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

320.6338

1.55

6.526316

M304TR0 750W 049

**

SP 12/07/17 (4)

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT017

320.633794

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

117797

0.75

120441

0.000794

121170

234.89

121666

51.91

M122312

7.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 24772 NJ

12/05/22

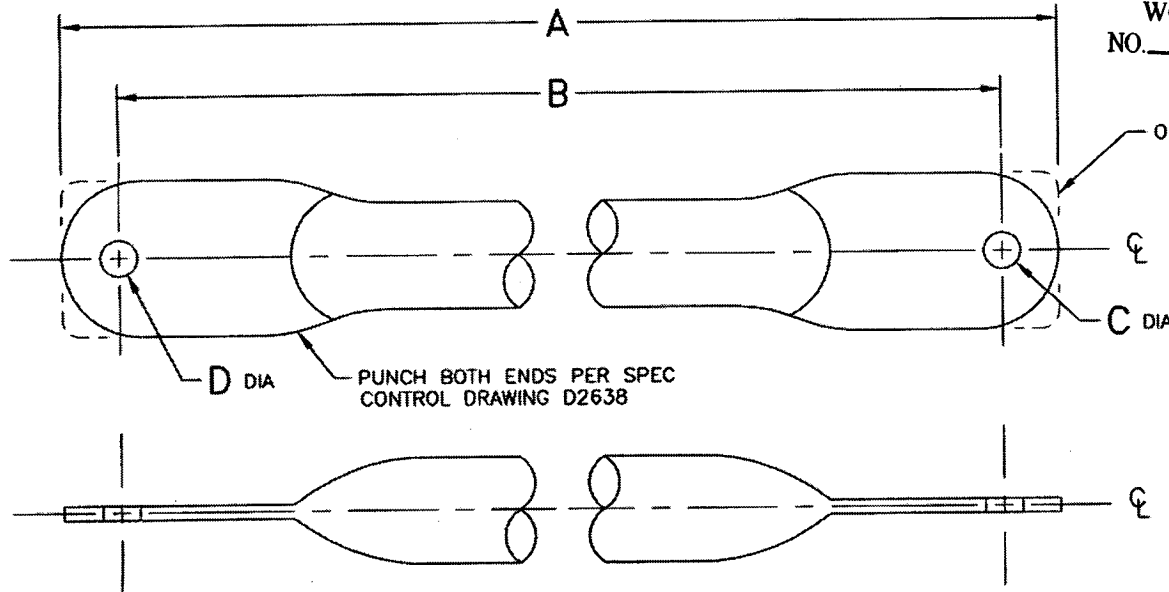
OPTIONAL

RELEASED
98.05.05
4E



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	98.05.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
B
B
C
C
C
D
D
E
E
E

#00.10.13
CP 00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 43/EI

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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